

Work Order ID 64892-1

December 22, 2010 7:11:46 AM

Page 1

Item ID: D3136-041

Accept

Revision ID:

Item Name: Window Assembly

Start Date: 12/21/10 Start Qty: 6.00

Required Date: 12/23/10 Req'd Qty: 6.00

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3136

Rev E

100

0.00



Waterjet

FLOW CNC Waterjet

FLOW WATER JET

Memo

0.00

1-Cut as per Dwg
Dwg Rev: E
Prog Rev: E
2-Deburr if necessary

10-12-22

110

0.00



QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

10-12-22

120

0.00



QC

Quality Control

QC8- Inspect parts - second check

Memo

0.00

8/10/12/22

(x5) (x7)

Pto →

3735
06/31

Dart Aerospace Ltd

W/O: 3		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3136-041 PAR #: _____ Fault Category: All Entered on the split. NCR: Yes ☒ No ☐ DQA: 7 Date: 11/01/20
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR: <u>64892-1</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
10/12/22	#160	Found At inspection that qty of (all) were cut to the original Dim (25.46", 22.63" should be 25.5025, 22.63 ±.030). Windows need to be	<u>JS/MLZ</u>	- Replace qty of (all) windows M <u>11533E</u> (2) Re make windows to match A/146 to	<u>18/10/22</u>	<u>8</u> 10/12/22	<u>JS/MLZ</u>	<u>01/12/22</u>
		At normal to avoid complus. R.C Jet needs to be replaced.	<u>JS/MLZ</u>	- Stock mat. under original to For use for smaller window	<u>21/10/22</u> <u>JS/MLZ</u>	<u>JS/MLZ</u>	<u>JS/MLZ</u>	<u>01/12/22</u>

NOTE: Date & initial all entries

Work Order ID 64892

December 22, 2010 7:11:47 AM



Page 2

Item ID: D3136-041

Accept



Setup Start



Revision ID:

Item Name: Window Assembly

Stop



Start Date: 12/21/10 Start Qty: 6.00



Cust Item ID:

Required Date: 12/23/10 Req'd Qty: 6.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130



Thermoform

THERMOFORMING MACHINE

0.00

Memo

0.00

x7

Wh

Thermoforming Machine

1-Thermoform as per Dwg D3136 and Folio FTA006 Dwg
Rev. E Folio Rev. C 2- Engrave Part # and
Batch # , and affix labels (D3108-9)

10/12/22

140



QC

QC2- Inspect parts off machine FAI/FAIB

0.00

Memo

0.00

x7

Wh

Quality Control

10/12/22

150



QC

QC8- Inspect parts - second check

0.00

Memo

0.00

8/10/12/23

(x6)

Quality Control

Out of 6 found no warping
no scratches or defects.

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December 22, 2010 7:11:48 AM



Page 3

Item ID: D3136-041

Accept



Setup Start



Revision ID:

Item Name: Window Assembly

Stop



Start Date: 12/21/10 Start Qty: 6.00



Cust Item ID:

Required Date: 12/23/10 Req'd Qty: 6.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160



Thermoform

HAND FINISHING THERMOFORMING

0.00

Thermoforming Machine

Memo

0.00

Water sand and buff to remove scratches as required

WLAS

170



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

Inspect edge and window deformation, wrap in plastic

8 Sours 123

(46)

180



Packaging

Packaging

Identify as per dwg & Stock Location: 218 0.00

Memo

0.00

12/23/10 (E)

Work Order ID 64892

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Page 4

Item ID: D3136-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Window Assembly

Start Date: 12/21/10 Start Qty: 6.00



Cust Item ID:

Required Date: 12/23/10 Req'd Qty: 6.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/12/23

MF

10-12-23

December 22, 2010 7:11:45 AM

Work Order ID: 64892

Parent Item: D3136-041

Parent Item Name: Window Assembly





Start Date: 12/21/10

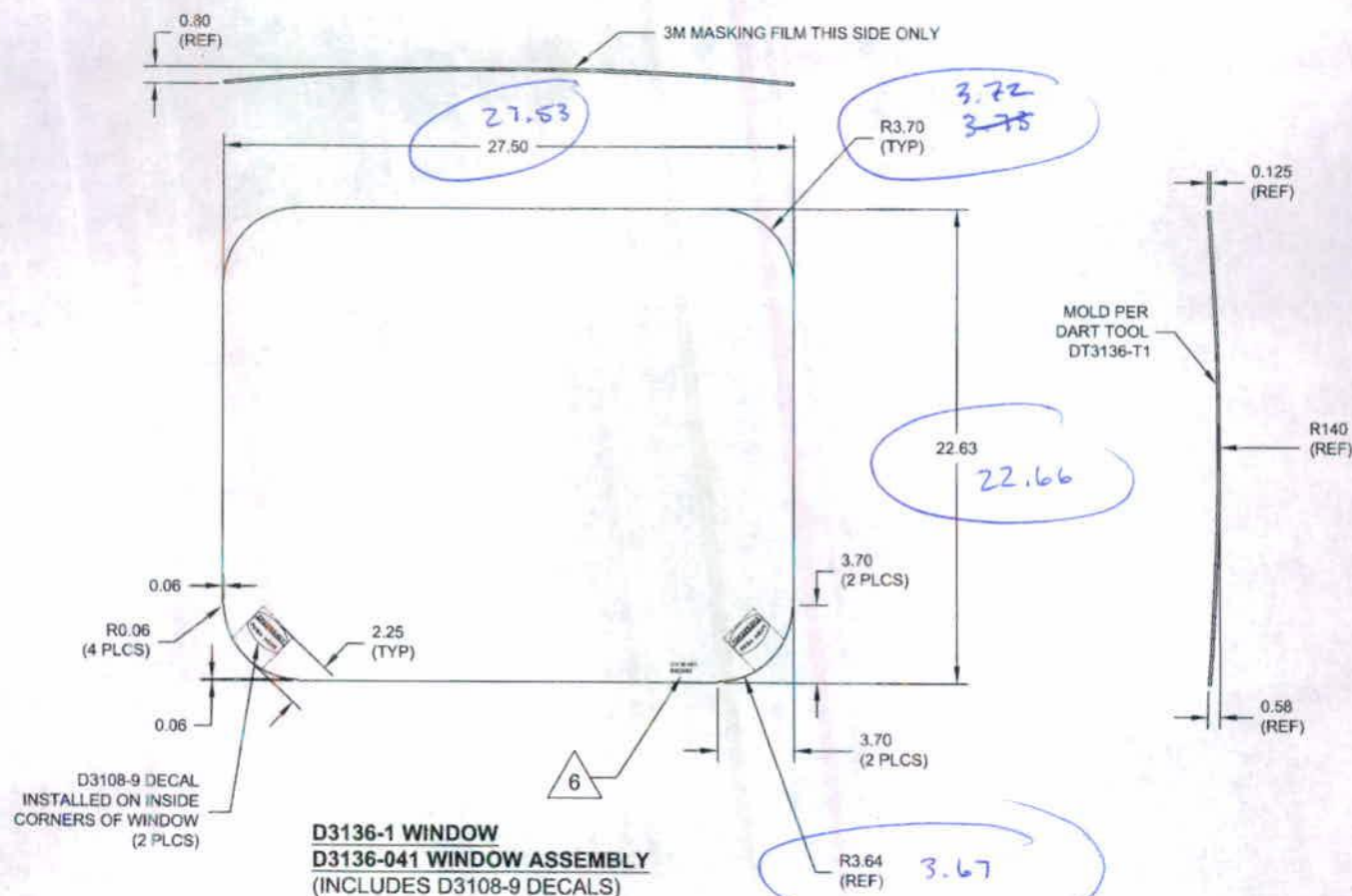
Required Date: 12/23/10

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP B 04.02.04 Reformat KJ/DS
IPP C Thermoform in house 05/07/2007 DL
IPP D Rev E 07.09.28 EC verified by: DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3108-9 		Manufactured	No			100	Each	642.0000	2	12			
Decal													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST036				642					
				34554				142					
				46546				500					
MACRLICS.125 		Purchased	No			170	sf	230.3222	4.25	26.84211			
1/8" Polycast II Sheet													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				MAT				230.3222					
				113204				4					
				113861				10.4					
				114673				9.6722					
				115338				206.25					



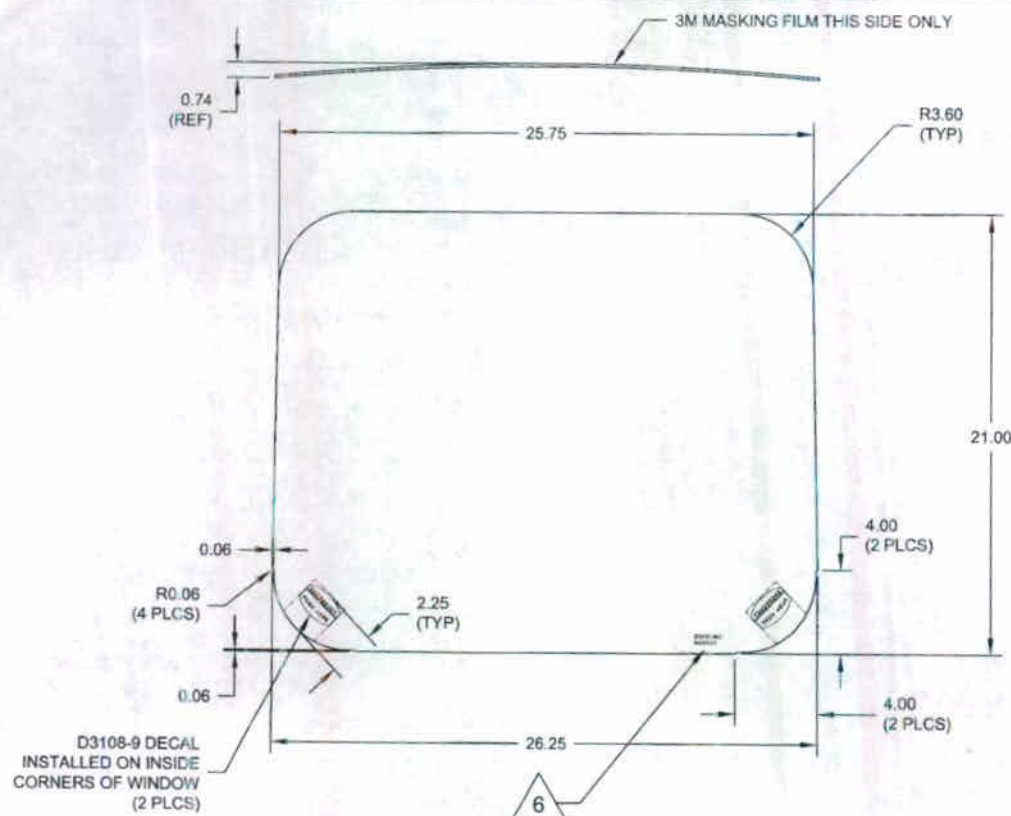
NOTES:

- 1) MATERIAL: POLYCAST II CLEAR ACRYLIC SHEET PER MIL-P-5425 OR PLEXIGLAS G CLEAR CAST ACRYLIC SHEET PER LP-391 TYPE 1 GRADE C, 0.125 THICK
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) REMOVE SHARP EDGES
- 6) IDENTIFICATION: ENGRAVE P/N "D3136-041" AND B/N ON LOWER EDGE
USE 0.125" HIGH LETTERS TO MAXIMUM DEPTH OF 0.005"
- 7) WEIGHT: 2.98 +/- 0.66 LBS
- 8) FORMING PROCESS: a) HEAT LARGER PIECE TO 250° F
b) DRAPE OVER D3136-T1 MOLD & CLAMP
c) LEAVE FOR 2 HOURS COVERED WITH INSULATED BLANKETS

E	REMOVE TRIM NOTE	DC	07.09.10
D	UPDATED MATERIAL NOTES	RF	05.12.01
C	ADDED FORMING & ENGRAVING SPEC	KJ	04.05.05
B	ADDED D3136-3 AND D3136-043	RF	04.01.21
A	NEW ISSUE	DS	02.04.18
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	07.09.10		

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D3136	REV. E SHEET 1 OF 2
TITLE WINDOW ASSEMBLY	SCALE 1:6

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D3136-3 WINDOW
D3136-043 WINDOW ASSEMBLY
 (INCLUDES D3108-9 DECALS)

NOTES:

- 1) MATERIAL: POLYCAST II CLEAR ACRYLIC SHEET PER MIL-P-5425 OR PLEXIGLAS G
 CLEAR CAST ACRYLIC SHEET PER LP-391 TYPE 1 GRADE C, 0.125 THICK
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) REMOVE SHARP EDGES
- 6) IDENTIFICATION: ENGRAVE P/N "D3136-043" AND B/N ON LOWER EDGE
 USE 0.125" HIGH LETTERS TO MAXIMUM DEPTH OF 0.005"
- 7) WEIGHT: 2.61 +/- 0.58 LBS
- 8) FORMING PROCESS: a) HEAT LARGER PIECE TO 250°F
 b) DRAPE OVER D3136-T1 MOLD & CLAMP
 c) LEAVE FOR 2 HOURS COVERED WITH INSULATED BLANKETS

MOLD PER
 DART TOOL
 DT3136-T1

RELEASED
 07.09.22

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. E
MFG APPR.		D3136	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		WINDOW ASSEMBLY	1:
DATE	07.09.10	COPYRIGHT © 2002 BY DART AEROSPACE LTD	
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